



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3278-2

Job Sheet 181642



Part No: D3278-2

Job Qty: 40 ea

Part Name: Support



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 8/2/18

Job Tracking No:

Created By: Marie Lajeunesse

Due Date: 8/10/18

Type: Stock

Description:

Note: DWG REV C IPP: A 04.04.19 New issue KJ/JLM IPP B 07.09.06 Rev C dwg EC Verified by: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	40 Ea	8/10/18	8/10/18	0.00	0.00	Start Up Machining-2		amml 18/08/18
100	Bandsaw	40 pcs	8/10/18	8/10/18	0.00	2.00	Bandsaw1		
110	CNC Vertical Machining	40 pcs	8/10/18	8/10/18	0.06	17.17	HAAS 5 Axis		
120	Outsource	40 pcs	8/10/18	8/10/18			MEM001-VC		SEP 26 18
130	QC	40 pcs	8/10/18	8/10/18	0.00	0.00	QC8 Machining-2		SEP 27 2018 38
140	HandFinish	40 pcs	8/10/18	8/10/18	0.00	4.12	HandFinish1		DR 18/09/18 68
150	Powdercoat	40 pcs	8/10/18	8/10/18	0.00	0.82	Powdercoat1		SEP 28 2018 68
160	QC	40 pcs	8/10/18	8/10/18	0.00	0.00	QC3		SEP 28 2018 68
170	Packaging	40 pcs	8/10/18	8/10/18	0.00	0.00	Packaging3-1		SEP 28 2018 68
180	QC21-SA	40 Ea	8/10/18	8/10/18	0.00	0.00	QC21		OCT 02 2018

Part Op 100 - Cut blank: 2.00" x 1.00" x 2.550" long
Descriptions: 150 - START TIME: 2:45 00:13:30 FINISH: 3:15 11:53:43
170 - LOCATION : GA

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X02.000	6061-T6 Bar 1.00 X 2.00	8.6800 ft (.217 ea)	90-Start up Operation	5098045

8.78 (.220)

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X02.000	9	33	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Support	0.098inches + 0.005 - 0.000	0.103 0.098		
2	Support	0.359inches ± 0.005	0.364 0.354		
3	Support	0.609inches ± 0.010	0.619 0.599		
4	Support	0.250inches ± 0.010	0.260 0.240		

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐									
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval							
Description Work Order Deviation			Disposition								
1270 Aberdeen Street Newbury, ON K6A 1K7 CANADA TEL: 1 813 632-5200 Email: sales@dartaero.com www.dartaerospace.com Container No: S104961 Part: D3278-2 Job No: 181642 Serial No/Batch: S104961 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: Various STC's			Completed By								
			Lead hand / Supervisor Approval Verification								
			QA Coordinator Approval								
			Root Cause <table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%; vertical-align: top;"> Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ </td> <td style="width:33%; vertical-align: top;"> No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> <td style="width:33%; vertical-align: top;"> Pressure/Bending ☐ Centre No ☐ Cracks ☐ Crimp/Kin ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twis ☐ Marks/Chatter ☐ </td> </tr> </table>			Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Bending ☐ Centre No ☐ Cracks ☐ Crimp/Kin ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twis ☐ Marks/Chatter ☐	<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:33%; vertical-align: top;"> Dimensions incomplete/Unclear ☐ Drill Holes ☐ </td> <td style="width:33%; vertical-align: top;"> Fit/Function ☐ Misaligned/off center ☐ </td> <td style="width:33%; vertical-align: top;"> Positioned Wrong ☐ de Dimensions ☐ 'Under tolerance ☐ ncorrect ☐ ost/Missing ☐ Moved ☐ ng ☐ Misread ☐ Turning Sequence ☐ </td> </tr> </table>		
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OTHER : ☐											

5	Support	1.480inches $\pm$ 0.005	1.485 1.475
6	Support	0.125inches $\pm$ 0.010	0.135 0.115
7	Support	0.119inches + 0.005 - 0.004	0.124 0.115
8	Support	2.439inches $\pm$ 0.010	2.449 2.429
9	Support	1.980inches $\pm$ 0.010	1.990 1.970
10	Support	0.130inches $\pm$ 0.030	0.160 0.100
11	Support	0.257inches + 0.005 - 0.000	0.262 0.257
12	Support	0.375inches $\pm$ 0.010	0.385 0.365
13	Support	0.875inches $\pm$ 0.010	0.885 0.865
14	Support	0.500inches $\pm$ 0.010	0.510 0.490
15	Support	0.400inches $\pm$ 0.010	0.410 0.390
16	Support	1.000inches $\pm$ 0.030	1.030 0.970
17	Support	1.720inches $\pm$ 0.010	1.730 1.710
18	Support	0.125inches $\pm$ 0.010	0.135 0.115
19	Support	0.125inches $\pm$ 0.010	0.135 0.115

Plex 8/2/18 2:33 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **PO040990**

Supplier: MEM001-VC
Metec Metal Technology Inc.
20 Terry Fox Drive PO Box 781
Vankleek Hill
ON
K0B 1R0 Canada
Phone: 613 678 3957
Fax: 613 678 3956

Attention: Walz, Shigi

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: PO040990
PO Date: 9/12/18
Due Date: 9/28/18
Purchase Order Revision:
Revision Date:
Ship-To Contact: Lussier, PatrickPhone:

Via: Ground
Pymt Terms: Net 60
Freight Terms:
Special Comments:

Revision

Items													
Line Item	Job	Part	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	181641	D3278-1			Support : Various STC's	Firmed	-	9/28/18	45 pcs	0 pcs	45 pcs	\$25.05/pcs	\$1,127.25
45 X SEP 25 2018													
Line Item Note Machining Only													
2	181642	D3278-2			Support : Various STC's	Firmed	-	9/28/18	21 pcs	0 pcs	21 pcs	\$25.05/pcs	\$526.05
21 X SEP 25 2018													
Line Item Note Machining Only													
3	183050	D3278-1			Support : Various STC's	Firmed	-	9/28/18	48 pcs	0 pcs	48 pcs	\$25.05/pcs	\$1,202.40
48 X SEP 25 2018													
Line Item Note Machining Only													
4	183075	D3278-2			Support : Various STC's	Firmed	-	9/28/18	72 pcs	0 pcs	72 pcs	\$25.05/pcs	\$1,803.60
72 X SEP 25 2018													
Line Item Note Machining Only													
Grand Total:												\$4,659.30	

DAS
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Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER PO040990

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

A005 RIGHT OF ENTRY
A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
A012 CHEMICAL AND PHYSICAL TEST REPORTS
A016 PERSONNEL QUALIFICATION
A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
A026 CERTIFICATION OF MATERIAL CONFORMANCE
A041 QUALITY MANAGEMENT SYSTEM
A042 DART NOTIFICATION BY SUPPLIER
A043 RETENTION OF QUALITY DOCUMENT

A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM

A049 SUPPLIER AWARENESS

A handwritten signature in black ink, appearing to be "P. Lussier", is written over the bottom right portion of the Order Notes section.

Plex 9/25/18 9:52 AM dart.Lussier.Patrick



www.metec.ca | 20 Terry Fox Drive, Vankleek Hill, Ontario, Canada K0B 1R0 | Phone: +1 613-678-3957 Fax: +1 613-678-3956

Packing List

Bill Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Ship Dart Aerospace Ltd.
To: 1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Canada

Att. Patrick Lussier

Shipment No: 24065
Shipment Date: 25-Sep-2018
Ship Via: Pick up at METEC
Order Number: 3019
Order Date: 09/12/18

Customer Code: DART
Phone: (613) 632-9577
PO Number: PO040990 ✓
Terms: Net 30 Days

----- Quantity -----								Job
<u>Item</u>	<u>Open</u>	<u>Shipped</u>	<u>B/O</u>	<u>Canceled</u>	<u>Unit</u>	<u>Description</u>	<u>Revision</u>	<u>Number</u>
1	90	93 ✓	0	0	EA	DART-D3278-1P Support, as per drawing D3278	C	3019-01
2	90	93 ✓	0	0	EA	DART-D3278-2P Support, as per drawing D3278-2	C	3019-02

JAS
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9-89

The delivered goods must be inspected upon receipt to confirm compliance. Should there be discrepancies please notify METEC within 30 days of delivery. The goods are otherwise deemed accepted.

Received In Good Order By
Att. Patrick Lussier



20 Terry Fox Drive, Vankleek Hill, Ontario K0B 1R0

Tel. (613) 678-3957 & (613) 678-2782 Fax (613) 678-3956 metec@metec.ca

CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

Quantity	Part Number	Part Name	Dwg Rev.#	Material Batch #	Paint Batch #	P.O. Number
93 ✓	D3278-1 ✓	Support	C	S109412	Unpainted	40990
				S109428	Unpainted	40990
				S109423	Unpainted	40990
21 ✓	D3278-2 ✓	Support	C	S104961	Unpainted	40990
72 ✓	D3278-2 ✓	Support	C	S104961	Unpainted	40990
				S109412	Unpainted	40990
				S109428	Unpainted	40990
				S109423	Unpainted	40990

DAE
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9-89

MATERIAL: supplied by DART

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Heather Nixon

Vankleek Hill, September 25, 2018